Work Order ID June-24-13 1:56:33 PM			*10	34	81*							Page 1	-,
Item ID: D3912-	3	·	Accept	*	N900	040	100)*	Setup	Start	*N	S1*	
Item Name: Eyebolt l	Block									Stop	*N	S2*	
Start Date: 6/24/13	Start Qty: 12.00	*12*			Cust Item I	D:							
Required Date: 7/05/13	Req'd Qty: 12.00	*12*			Customer:							:	
Reference:		17		1				_	_	~			
Approvals: Proces	s Plan: MUゴ	Date: 13-010-74	Tooling:		D	ate:		j	Run	Start	*N	R1*	
QC: _		Date:	SPC (Y/N):		D	ate:				Stop	*N	R2*	-1.
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr				,								
D3912	В											\$:
100	Cut blanks as per folio		0.00		MM	13/0	7/11	1	12	Ø	,		
Bandsaw	Memo		0.00								 		
Jeaspa Bandsaw	CUT BLAN	K 2.50" LONG											
110			0.00									2	
110 HAÁS 1	Memo	i .	0.00					12				113-7-	2
HAAS CNC vertical machine		AS PER FOLIO FA870 AN 7: 44 	ID DWG										

DEBURR

DQA:			Date:			WORK OBDED NON	~	SNEOI					`DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFOI	RIVIAINCE / U		Vork Order ι	pdate only	AEROSPACE
Mork Orde						DISPOSITION				AGAINST D	EPARTMEN	r/PROCESS	
Work Orde	=1					Rework			Skid-tube	Crosstube	\neg	Water Jet	Engineering
Part N	do.					Scrap			Machining	Small Fab	- Dr.	od. Eng. Coor.	Quality
T die i	•••					Use-as-is			noforming	Finishing		ore/Packaging	Other
NCR N	No.					Suspected Unapproved		1110111	Large Fab	Composite	→	Supplier	-
							' !		. 0.	' L	1	٠٠ ــ	
Root					Desc	ription of work order update	ı	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design						,							
Doc/Data	Ш												
Equip/Tooling													
Handling/Pre	Ш												
Material												•	
Operator	Щ												
Offset/Setup	Ш												
Process	Ш												
Supplier	Щ												
Training	Н												
Transport	Н												
Unapproved							<u> </u>						
							FA	ULT CA	regory				
Landi						General	_]_ :		г		. г	¬- ,-
		Bending			-	Bend	⊢	4	Program	-	Outside Di	 	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain			Over/Unde	-	Set-up
	┝─┤	Cracks	alı/Dimmla	/\A/==	\vdash	Broken/Damage/Defect	⊢	Hardwa			Part Incorr	<u> </u>	Temperature/Cure
	-	Crimp/Kii	пк/кірріе	/ wave	-	Burrs	⊢	1 '	ion Incomplete/Ui	· -	Part Lost/N	· ·	Weld
	—-	Crushina			-	Countarink	-	4	tions Incomplete/	Jnciear	Part Move	<u> </u>	Wrong Stock Pulled
	${f -}$	Crushing	\ +		-	Countersink Cut Too Short	┝	1 7	gned/off center	-	Positioned		Jothan
	-	Heat Treat Inspection		Tubo	\vdash		_	Mislabe		L	Power Loss	/surge [Other
	_	Marks/Ch	· .	rube		Drawing Drill Holes	_	Misread Off-set					
					-	Finish	-	4	Calibration				
·	Turning Sequence Wave/Twist in Tube			\vdash	Fit/Function	\vdash	4	Soguence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord	er ID 103 6:33 PM	3481		*10).34	481*							Page 2
Item ID: Revision ID:	D3912-3			Accept	:	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Eyebolt Block	-									Stop	*N	S2*
Start Date:	6/24/13	Start Qty: 12.00	*12*			Cust Item I	D:						
Required Date	: 7/05/13	Req'd Qty: 12.00	*12*			Customer:							
Reference:								_		ъ.	C4am4		
Approvals:	Process Pla	ın:	Date:	Tooling:		D:	ate:				Start	*N	R1*
	QC:		Date:	SPC (Y/N):	-	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hou	rs	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
*120		QC2- Inspect parts off ma	achine FAI/FAIB	0.00									-51137-21
QC Quality Control		Memo		0.00				٠					SLI) to
								ť					
130		QC8- Inspect parts - seco	ond check	0.00	_								
130 QC Quality Control		Memo		0.00	AS AS 9-89	13/07	/21		12	Ţ,	5		
160		Identify as per dwg & Sto	ock Location: 87	0.00									

0.00

Memo

160 Packaging

Packaging

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Vork Order u	odate only	AEROSPACE
						DISPOSITION					DEPARTMENT		
Work Orde	er: _					<u></u>				_		_	
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	NO				_	Scrap			Machining	Small Fab	⊣	d. Eng. Coor.	Quality
NCR f	No.					Use-as-is Suspected Unapproved		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCN	v o		· · · · · · · · · · · · · · · · · · ·			Suspected Onapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	Ш												
Handling/Pre	Ш												
Material	Щ												
Operator	Ш												
Offset/Setup	Ц				:								
Process	Ц												
Supplier	Н												
Training	Н						•				1		
Transport	Н												
Unapproved								, ML					
						 	FAL	ULT CAT	TEGORY				
Landi						General		1		_	_	_	7
	\vdash	Bending	_			Bend	Ш	1	rogram	L	Outside Dim	<u> </u>	Pressure/Forced
	Н		ot Concer	ntric		BOM/Route	lacksquare	Grain			Over/Under) —	Set-up
	Ь	Cracks			<u> </u>	Broken/Damage/Defect	\sqcup	Hardwa		-	Part Incorre		Temperature/Cure
	\vdash		nk/Ripple	/Wave	_	Burrs		1	ion Incomplete/Ur	· —	Part Lost/Mi	_	Weld
	\vdash	Cuffs			_	Contamination		1	ions Incomplete/L	Jnclear	Part Moved	L _	Wrong Stock Pulled
	-	Crushing	_		\vdash	Countersink		1 ~	ned/off center	<u> </u>	Positioned V		-
	\vdash	Heat Trea			<u> </u>	Cut Too Short	_	Mislabe		L	Power Loss/	Surge	Other
	-	•	n Strip in	Tube	-	Drawing		Misread	1				
	\vdash	Marks/Ch			<u> </u>	Drill Holes		Off-set					
	$\overline{}$	Turning S			_	Finish		1	Calibration				
	Wave/Twist in Tube				Fit/Function		Out of 9	Sequence					

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Work Ord <i>June-24-13 1:5</i>		3481			*103	3481*							Page 3	
Item ID: Revision ID: Item Name:	D3912-3 Eyebolt Block				Accept	*N900	<u> </u>	100	*	Setup	Start Stop		S1*	
Start Date: Required Date	6/24/13 : 7/05/13	Start Qty: 12.00 Req'd Qty: 12.00		*12* *12*		Cust Item Customer								
Reference:	Process Pla	ın:	Date:		Tooling: SPC (Y/N):		Date:			Run	Start Stop		R1* R2*	·
Sequence ID/ Work Center I	D	Operation Description	Worls Ondon	Dalassa	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	1/

0.00

Memo

170

Quality Control

Qty Number Stamp

13/7/24

MB-1-33

DQA:			Date:											•	DART
						WORK ORDER NON-	-C(ONFO	RMANCE / UP	PDATE				_	AEROSPACE
QA Closed:			Date:								W	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	_	·			_ 1	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part 1	No.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	\dashv	Quality
				 		Use-as-is	1 1	1	noforming	Finishing		4	re/Packaging		Other
NCR I	No					Suspected Unapproved			Large Fab	Composite			Supplier		
												•	_		
Root					Descr	ription of work order update		Initial	Acti	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification		QC Inspector
Design	Ш														
Doc/Data															
Equip/Tooling	Ш						1								
Handling/Pre	Ш														•
Material	Н														
Operator '	\vdash														
Offset/Setup	Н													- 1	
Process Supplier	H						l								
Training	Н						-							1	
Transport	H														
Unapproved	H														
	Ш			L			FAI	ULT CA	TEGORY			1	L.,.		
Landi	ng Ge	ar				General									
	В	ending				Bend	Γ	Folio/F	rogram			Outside Dim	ensions	\Box	Pressure/Forced
	Ce	entre No	t Concer	ntric		BOM/Route		Grain	_			Over/Under	tolerance	_	Set-up
	Cr	racks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct	7	Temperature/Cure
	∐ Cı	rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	7	Weld
	L Cı	uffs				Contamination		Instruct	ions Incomplete/U	nclear		Part Moved		\	Wrong Stock Pulled
	⊢	rushing	•			Countersink		Misalig	ned/off center			Positioned V			
		eat Trea				Cut Too Short	L	Mislabe	eled			Power Loss/	Surge		Other
	⊢	•	Strip in	Tube		Drawing	L	Misread	t				-		
:	_	larks/Ch				Drill Holes		Off-set							
:	_		equence			Finish	L	4	Calibration						
	l IW	/ave/Tw	ist in Tub	e		Fit/Function	1	Out of	Sequence						

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Picklist Print

June-24-13 1:56:32 PM

Work Order ID:

103481

Parent Item:

D3912-3

Parent Item Name:

Eyebolt Block

Start Date: 6/24/13

Required Date: 7/05/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	0.0000	0.208	2.6273688			

MH 13/07/11

1126132

2.675



DQA:			Date:										DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Vork Order uj	odate only	AEROSPACE
						DISPOSITION					EPARTMENT	-· ··	
Work Orde	er: _						,			_	—		
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	No					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
NCR N	۷o			· - -		Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root	_				Desci	ription of work order update		Initial	Δct	tion	Sign &		
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng	ļ	ription	Date	Verification	QC Inspector
Design	\top		0.00	~:,		or more companies	1		2000	iption	- Dute	Vermeation	Qe mspector
Doc/Data													
Equip/Tooling											1		
Handling/Pre				:									
Material													
Operator													
Offset/Setup													
Process									1				
Supplier													
Training													
Transport													
Unapproved													
							FA	ULT CA	regory		•		
Landi	ng Ge	ar				General		_					
	ШВ	ending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
		entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		iracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct 🗌	Temperature/Cure
		rimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld
		uffs				Contamination		Instruct	ions Incomplete/l	Jnclear [Part Moved		Wrong Stock Pulled
		rushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
	L ⊦	leat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
!	<u> </u> '	nspection	Strip in	Tube		Drawing		Misread	d	_			
	<u></u>	/larks/Ch	atter			Drill Holes		Off-set					
	Шт	urning S	equence			Finish		Out of	Calibration				
	v	Vave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

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DART AEROSPACE LTD	Work Order:	103481
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: B		Page 1 of 1

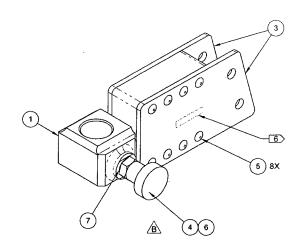
FIRST ARTICLE INSPECTION CHECKLIST

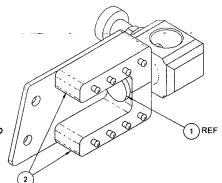
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	+/-0.030	2302			vern	1-10
Ø0.129	+0.005/-0.001	129			\ \rac{1}{\sqrt{1}}	<u> </u>
0.50 Ref	+/-0.030	497			-	
R0.13	+/-0.030	-125			R-G	
0.500	+/-0.010	494	/		11-(-	
R0.125	+/-0.010	-125			R-G	
0.63	+/-0.030	-626			ven	21-10
0.750	+0.000/-0.020	-736			~	<u> </u>
0.38	+/-0.030	-376			~	
1.500	+/-0.010	1-500			~	
0.500 Pitch	+/-0.010	-500			~	
0.800	+0.000/-0.010	-800			_	
0.400	+/-0.010	-400	/		-	
0.516	+0.015/-0.000	-520	/		~	
1.00	+/-0.030	991				
		-				
						·
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	 	S AS		
Measured by:	Audited by:	44	Preliminary Approval:	
Date: 3-7-20	Date:	13/07/21	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 🔥	,,pp.ovou
В	12.05.15	Dwg Rev updated	KJ OA	(Tint
			THE STATE OF THE S	Lefont.

ITEM	QTY -041	PiN	DESCRIPT O .	
	Х	D3912-041	EYEBOLT RECEIVER ASSY	
1	1	D3912-1	EYEBOLT	
2	2	D3912-3	EYEBOLT BLOCK	
3	2	D3912-5	EYEBOLT PLATE	
4	1	D3801-1	SPRING PLUNGER B	
5	8	MS20615-4M20	-RIVET	
6	1	MS21209-F615	HELICAL	
7	1	NAS1149F0332P	WASHER B	





SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

1) MATERIAL: N/A

1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER

8

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; M521209-F615 WAS M521209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. 10.06.28 NEW ISSUE Α 10.03.04 DESCRIPTION BY DATE

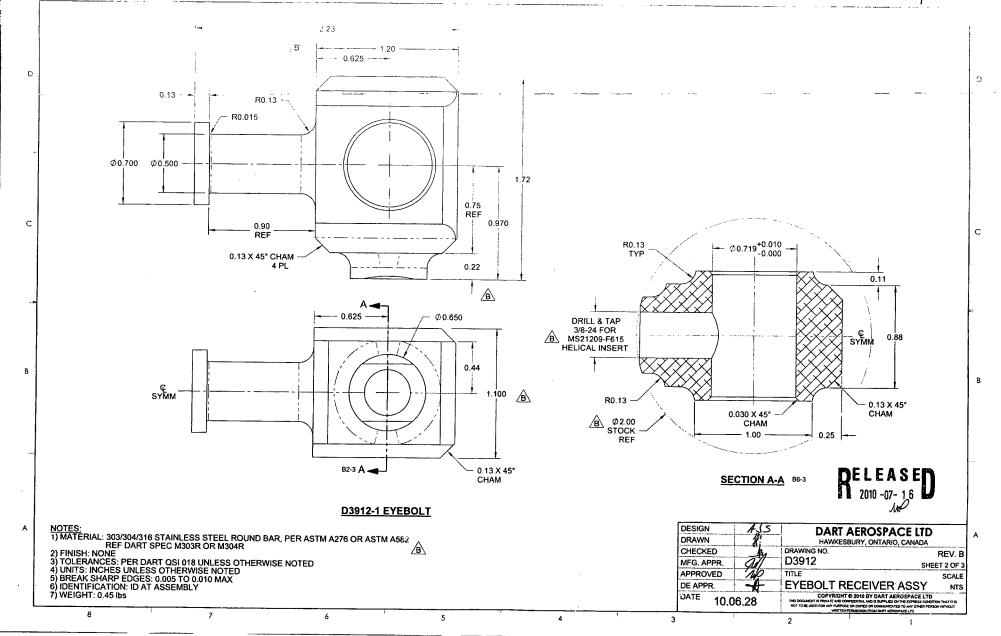
REV. DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY DE APPR. NTS CC PYRIGHT © 2010 BY DART AEROSPACE LTD

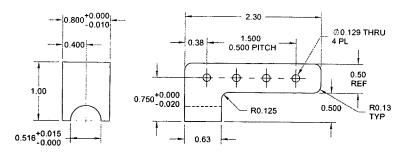
"10 MINITE NO CONFEDITIA, AND SUPPLED ON THE EXPRESS CONDITION THAT IT IS

EED FOR JANY PURPOSE OR COMPED OR COMMANICATED TO JANY OTHER PERSON WITHOUT DATE 10.06.28

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6





D3912-3 EYEBOLT BLOCK

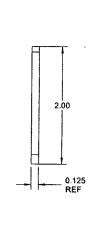
NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

8

- 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: ID AT ASSEMBLY
 7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

3.15 1.500 0.500 PITCH <u> 1</u>0.375 R0.13 -- 0.38 0.25 0.517 1.000 1.500+0.020 REF Ø0.129 Ø0.257 8 PL 2 PL 3.69 REF



D3912-5 EYEBOLT PLATE

DESIGN ASS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN #		
CHECKED		DRAWING NO. REV B
MFG. APPR. Qui		D3912 SHEET 3 OF 3
APPROVED A		TITLE SCALE
DE APPR.	-#	EYEBOLT RECEIVER ASSY NTS
DATE 10.0	06.28	COPYRIGHT © 2010 BY DART / EROSPACE LTD THIS DOCUMENT IN PROVIDE ON THE DOMEST CONCIDENT THAT IT IS NOT TO BE USED FOR AMP PURPOSE ON COMPUDE OF THE DOMEST SCHOOLTION THAT IT IS NOTITIO BE USED FOR AMP PURPOSE ON COMPUDING ACTUST TO THE PURPOSE WHITHOUT NOTITION PURPOSES ON THOSE OF THE PURPOSE OF THE